

Work Order ID 81490

March-14-12 4:22:13 PM

81490

Page 1

ASAP

Item ID: D3639-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 14/03/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/14

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3639	Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639 Dwg Rev: A Prog Rev: A 2-
Debur if necessary

B12-3-20

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-20

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12.03.22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81490

Page 2

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 14/03/2012 **Start Qty:** 12.00 ***12***

Required Date: 23/03/2012 **Req'd Qty:** 12.00 ***12***

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

130

130

NC BRAKE

0.00

0.00

Form as per Dwg D3639

SB 12/03/28

QC5- Inspect part completeness to step on W/O

0.00

140

Memo

0.00

Quality Control

4/2

2

Chemical Conversion Coat per QSI005 4.1

0.00

150

Memo

0.00

Hand Finishing

12x0 m-12/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81490

81490

Page 3

March-14-12 4:22:13 PM

Item ID: D3639-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 14/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

12 BK 12-3-29

170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									

12 SP 12-03-30

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/12

12-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 4:22:16 PM

Page 1

Work Order ID: 81490

81490

Parent Item: D3639-1

D3639-1

Parent Item Name: Doubler

Start Date: 14/03/2012

Required Date: 23/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	33.9000	0.239	3.018947			

M2024T3S 050

2024-T3 .050 sheet

**

B12-3-20

Location

Loc Qty

Loc Code

MAT022

33.9

117684

33.9

117684

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81490
Description: Doubler		Part Number:	D3639-1
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.624	x		V 1B02	
Ø0.191	+0.005/-0.001	.191	2		V	
Ø0.098	+0.004/-0.001	.098	2		V	
0.69	+/-0.030	.691	2		V	
1.59	+/-0.030	1.589	2		V	
2.49	+/-0.030	2.49	2		V	
3.39	+/-0.030	3.393	2		V	
3.990	+/-0.010	3.943	2		V	
4.990	+/-0.010	4.992	2		V	
5.19	+/-0.030	5.193	2		V	
6.99	+/-0.030	6.989	2		V	
8.64	+/-0.030	8.645	2		PROW307	
0.45	+/-0.030	.449	2		V	
0.710	+/-0.010	.710	2		V	
2.000	+/-0.010	2.000	2		V	
2.75	+/-0.030	2.759	2		V	
3.55	+/-0.030	3.555	2		V	
4.00	+/-0.030	4.009	2		V	
2.000	+/-0.010	2.002	2		V	
2.590	+/-0.010	2.591	2		V	

Measured by:	B	Audited by:	M Val	Prototype Approval:	N/A
Date:	12-3-20	Date:	12-03-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AS

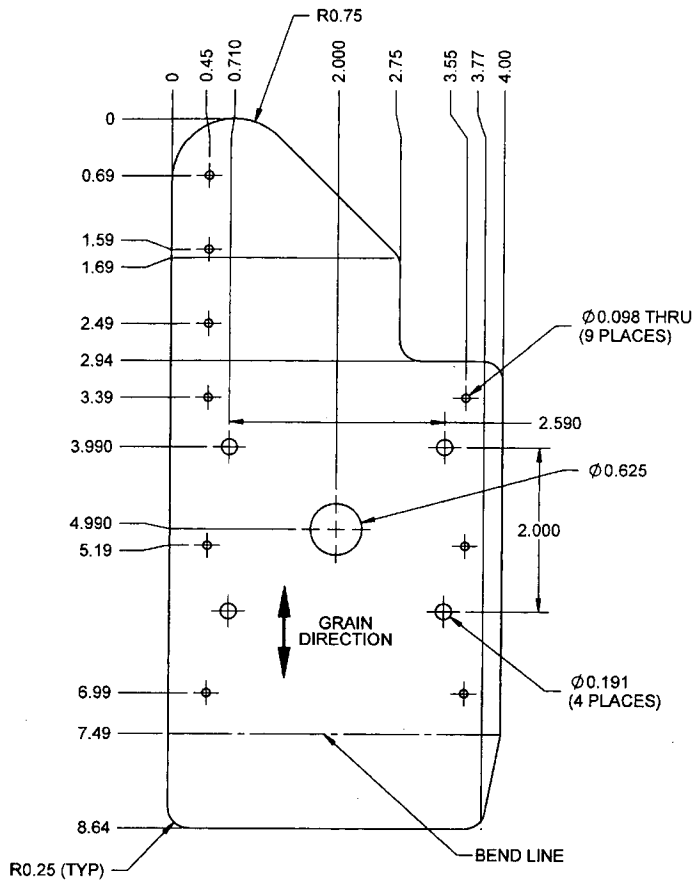
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

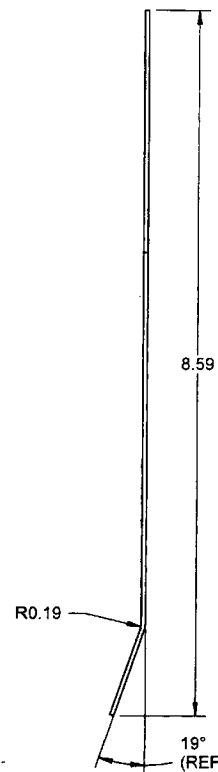
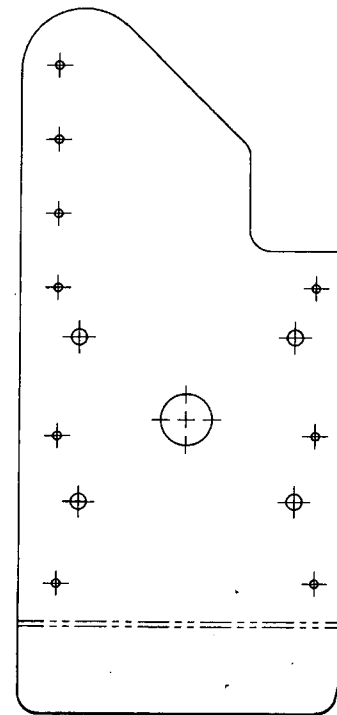
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81490 MJS
12/03/14



**D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)**

RELEASED
07-07-07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	B		
MFG. APPR.	B		
APPROVED	B		
DE APPR.	B		
DATE	07.07.27		
		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
		DRAWING NO. D3639	REV. A SHEET 1 OF 2
		TITLE DOUBLER	SCALE 2:3
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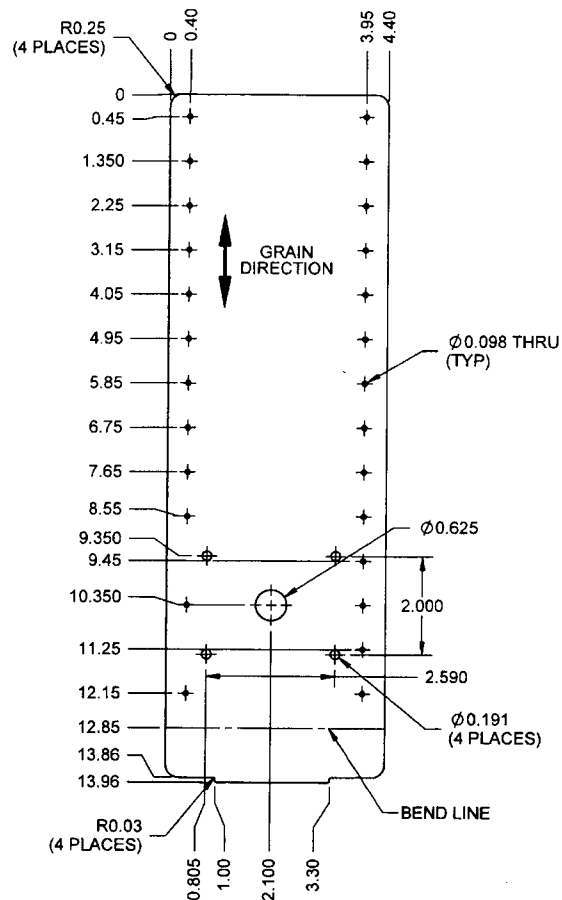
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

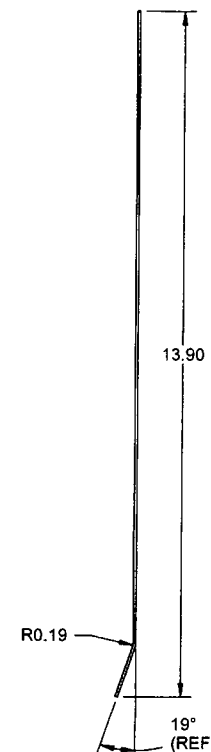
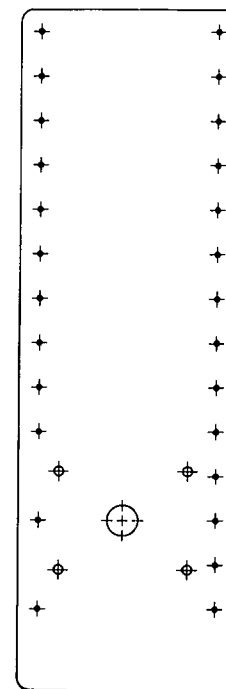
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NOTE: Date & initial all entries



D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)



21490



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)

RELEASED
07.09.07 #

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	JE	DRAWING NO.	REV. A
MFG. APPR.	JE	D3639	SHEET 2 OF 2
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	DOUBLER	2:5
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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